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FORM P	TO-1390	(Modified) U.S. DEPARTMENT	OF COMMERCE PATENT AND TRADEMARK OFFICE	ATTORNEY'S DOCKET NUMBER		
(REV II	-2000) TR	ANSMITTAL LETTER	TO THE UNITED STATES	217958US3PCT		
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			G UNDER 35 U.S.C. 371	10/030939		
INTE	NATI	ONAL APPLICATION NO. PCT/JP00/04980	INTERNATIONAL FILING DATE 26 JULY 2000	PRIORITY DATE CLAIMED 28 JULY 1999		
TITLE	OF IN	VENTION				
GAS	GEN	ERATOR				
		r(s) for do/eo/us				
AFFL	CAN	(3) POR BO/EO/OU				
Akib	iko S	UEHIRO, et al.				
Appli	cant h	erewith submits to the United Sta	ites Designated/Elected Office (DO/EO/US) t	he following items and other information:		
1.	×		tems concerning a filing under 35 U.S.C. 371			
2.			UENT submission of items concerning a fili			
3.	⊠	This is an express request to beg	in national examination procedures (35 U.S.	C. 371(f)). The submission must include itens (5),		
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		 is attached hereto. 				
C).	•		bmitted under 35 U.S.C. 154(d)(4).			
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8.			of the amendments to the claims under PCT	Article 19 (35 U.S.C. 371(c)(3)).		
9.	\boxtimes	An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)). An English language translation of the annexes to the International Preliminary Examination Report under PCT				
10.		An English language translation Article 36 (35 U.S.C. 371 (c)(5)	of the annexes to the International Preliminal).	ary Examination Report under PC1		
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13.	⊠		ement under 37 CFR 1.97 and 1.98.			
14.		An assignment document for re-	cording. A separate cover sheet in compliance	ce with 37 CFR 3.28 and 3.31 is included.		
15.		A FIRST preliminary amendme				
16.		A SECOND or SUBSEQUENT				
17.		A substitute specification.	·			
18.		A change of power of attorney	and/or address letter.			
19.		A computer-readable form of th	e sequence listing in accordance with PCT R	Lule 13ter.2 and 35 U.S.C. 1.821 - 1.825.		
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1		Notice of Priority / PCT/IB/30				
1		PTO-1449 / Drawing (1 sheet)				

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24.	The fo	llowing fees are submitted:.					CAL	CULATIONS	PTO USE ONLY
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Specification

GAS GENERATOR

5 Technical Field

The present invention relates to a gas generator for use in an airbag safety system for safely protecting a driver and occupant from an impact caused by a collision of an automobile or the like.

Background Art

The gas generators of this type include the one having a housing made of an aluminum alloy, iron, or steel. Because a housing made of an aluminum alloy is readily molded compared to a housing made of iron or steel, in some housings, an ignitor holding portion for fixing an ignitor is integrally formed at a center of a lower lid, as disclosed in Japanese Unexamined Patent Publication No. Hei 10-081190. In some housings made of iron or steel, for example, an ignitor holding portion (a holder for an ignitor), that is another member, is fixed by welding on a press-formed lower lid, as disclosed in Japanese Unexamined Patent Publication No. Hei 11-078764.

In consideration of environment and safety, there is a tendency to change an azidation gas generating agent in which

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sodium azide is used to a nitrogen containing organic-compound gas generating agent.

However, a combustion temperature of the nitrogen containing organic compound gas generating agent is likely to be high compared to that of the azidation gas generating agent. A higher pressure is required to keep the same level of burning characteristic and a housing made of an aluminum alloy and having a construction of a single cylinder has a limit in heat resistance and pressure resistance.

A housing should have a sealing construction to protect a gas generating agent from deterioration by moisture absorption. If an ignitor holding member is fixed by welding on the housing made of iron or steel, in addition to a welding process, there is a possibility that a problem occurs with regard to reliability in sealing of a welded portion. Therefore, from necessity to keep the reliability, a leak test should be carried out beforehand.

Similarly, in a case that the ignitor holding member is fixed by caulking, it is necessary to add a sealing member such as a packing, to fix by caulking, and to carry out a seal test.

In a case that a length in an axial direction (L) is shorter than a diameter (D) of a gas generator (L/D \leq 1), a lower lid cannot be so thick as to prevent a modification by a high internal pressure generated at the time of burning of a gas generating agent. If the

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lower lid is modified by a pressure generated at the time of burning of the gas generating agent, there may occur a leak of a combustion gas with a damage of a welded portion of an ignitor holding portion and unfixing of a caulking. There is an adverse possibility that the leaked combustion gas does not go through a cooling/filtering member.

It is an object of the present invention to solve various problems described above, specifically, to provide a gas generator suitable for a nitrogen containing organic compound gas generating agent and excellent in heat resistance, pressure resistance, and sealing.

Disclosure of the Invention

A gas generator of the present invention is so structured that a housing is formed by joining an iron- or steel-made upper lid, containing a top plate and a side cylinder extending downward from an entire circumferential edge thereof and provided with many gas discharge holes with an iron- or steel-made lower lid, containing a bottom plate, side cylinder extending upward from an entire circumferential edge thereof, and an ignitor holding portion formed integrally with the bottom plate and for fixing by caulking an ignitor. In the housing, the ignitor and a gas generating agent are arranged in the order mentioned from a center thereof. A flange

extending horizontally outward from the side cylinder of the top plate is formed. The integral forming is done by a repetition of pressuring iron or steel to flow. The lower lid is formed into a ball-like shape. The ignitor holding portion comprises an inner side cylindrical portion standing on a wall thickness portion of the bottom plate of the ball-like lower lid and holding the ignitor, a protruding portion protruding into a center from the inner side cylindrical portion and mounting the ignitor, and a bending portion extending from the inner side cylindrical portion, bending towards the center, and fixing the ignitor by caulking. Organic-compound gas generating agents containing mainly nitrogen are disposed in the housing.

Hence, the ignitor holding portion is formed integrally with the bottom plate in the gas generator of the present invention, a sealing test of the ignitor holding portion is not necessary. It is possible to protect the gas generating agent from deterioration by moisture absorption caused by a defective seal. Because the lower lid is made of high strength iron or steel, it is also possible to prevent the lower lid from being modified by a high internal pressure generated at the time of burning of a nitrogen containing organic compound. The lower lid and the ignitor holding portion are formed integrally. As a result, it is possible to prevent a sealing portion from being damaged even if the lower lid is modified

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by the internal pressure.

Because the flange is formed on the upper lid side, the ignitor holding portion can be formed integrally on the lower lid side.

By a repetition of pressuring iron or steel to flow by partial forging, spinning or the like, it is possible to form the ignitor holding portion integrally with the lower lid even if the lower lid is made of iron or steel. Also, the lower lid is formed into a ball-like shape. As a result, a high mechanical strength can be shown. As a result, it is also possible to prevent the lower lid from being modified by a high internal pressure generated at the time of burning of a nitrogen containing organic-compound.

The ignitor holding portion is formed by a repetition of pressuring iron or steel to flow, it is possible that the ignitor holding portion is formed integrally from the bottom plate into an interior of the housing in a standing shape. Therefore, a sealing of the ignitor holding portion is not necessary to be tested. As integrally formed, the ignitor holding portion can keep a high strength and prevent a seal from being damaged even if the lower lid is modified by the internal pressure generated at the time of burning of organic compound gas generating agents.

As mounted on the lower lid over a wall thickness portion, the ignitor holding portion can keep a higher strength and prevent

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a seal from being damaged more reliably.

Because the ignitor holding portion is integrally formed, a wall thickness of the lower lid can be thickened even if L/D is no more than 1.

Brief Description of the Drawings

FIG. 1 is a schematic sectional view showing an entire structure of an example of a gas generator according to the present invention.

Best Mode for Carrying Out the Invention

The embodiments of a gas generator according to the present invention will be described below with reference to the drawing.

FIG. 1 is a schematic sectional view showing an example of the gas generator of the present invention. As shown in FIG. 1, a gas generator G1 is composed of an iron or steel made upper and lower lids 2 and 3.

Iron or steel to be used may be wrought iron, iron, steel, steel alloy, and the like generally used in forging, spinning, and press-forming and the like and is not specifically limited.

The upper lid 2 is composed of a top plate 2a, a side cylinder 1a extending downward from the entire circumferential edge thereof and provided with many gas discharge holes 8, and a flange

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1c extending vertically outward from the side cylinder 1a and mounting an airbag module (not shown).

The lower lid 3 is composed of a bottom plate 3f, a side cylinder 1b extending upward from the entire circumferential edge thereof, and an ignitor holding portion 3a formed integrally with the bottom plate 3f and for fixing by caulking an ignitor 30.

The upper lid 2 and the lower lid 3 are formed by a repetition of partial pressuring to flow. In this case, the repetition of partial pressuring to flow means to partially repeat general forging and spinning processes. Therefore, the upper lid 2 and the lower lid 3 are made of a single plate-like iron or steel or a single block-like iron or steel by using a metal pattern for example, and combining methods of forging, spinning, pressing processes and the like.

By the partially repetition of pressuring to flow as described above, it is possible to form the top plate 2a and the bottom plate 3f of the upper lid 2 and the lower lid 3 into a ball-like shape, wherein the lower lid has enough pressure resistance not to be modified by the internal pressure generated at the time of burning of a nitrogen containing organic-compound.

Because a flange 1c is formed with the upper lid 2 for mounting an airbag module, it is not required to excessively complicate a form of the lower lid 3 integrally formed with the ignitor holding portion 3a. As a result, the ignitor holding portion

3a can be formed integrally.

It is preferable that the ignitor holding portion 3a is formed in the center of the bottom plate 3f in view of strength. The ignitor holding portion 3 according to the embodiments of the present invention is composed of an inner side cylindrical portion 3b standing on a wall thickness portion 3e of the bottom plate 3f of the ball-like lower lid 3 and holding the ignitor 30, a protruding portion 3d protruding into a center from the inner side cylindrical portion 3b and mounting the ignitor 30 over a packing 31, and a bending portion 3c extending from the inner side cylindrical portion 3b, bending towards the center, and fixing the ignitor 30 by caulking.

Because the inner side cylindrical portion 3b is formed to stand on the wall thickness portion 3e of the bottom plate 3f as described above, the ignitor holding portion 3a is excellent in mechanical strength. Therefore, the ignitor holding portion 3a is not damaged by an internal pressure generated in combustion of the gas generating agent 6 even if the lower lid 3 is modified. Also, the ignitor holding portion 3a is integrally formed, there is no problem on sealing and a leak test is not required. It is not required to form the inner side cylindrical portion 3b over the wall thickness portion 3e. The side cylindrical portion 3b may be formed to stand on the bottom plate 3f directly.

The upper lid 2 and the lower lid 3 formed as described above forms a single cylindrical housing 4 abutting and joining side cylinders 1a and 1b with each other. Hence, a joining method is electron beam welding, laser welding, friction welding and the like.

Because the gas generator G1 of the present invention has a housing construction of a single cylinder, the side cylinder 1 should bear all force added in an axial direction against the internal pressure generated by combustion of the gas generating agent 6. For a reason mentioned, it is preferable that a diameter (D) of the gas generator is no more than 70 mm. A length (L) in an altitudinal direction is preferable to be no more than 70 mm for a passenger seat and no more than 40 mm for a driver's seat to be incorporated in an airbag module (not shown).

A cooling/filtering member 7 is mounted throughout the upper lid 2 and the lower lid 3 in the housing 4 and a gas generating agent 6 is loaded being held by a cushion member 5 and a fixing lid member 9a therein. A ring member 9b having an L-shaped section is disposed abutting with a lower end of the cooling/filtering member 7 at the inside thereof. Both the fixing lid member 9a and the ring member 9b have a function of preventing a generated gas from flowing out from a gap between an inner surface of the housing and the cooling/filtering member 7. The gap appears by a modification of the housing 4 which occurs

when the gas generator G1 actuates. A cylindrical punched metal 11 having many holes on an outer periphery thereof is disposed on an outer periphery of the cooling/filtering member 7. The punched metal 11 has a function of preventing the cooling/filtering member 7 from being crushed by a gas pressure generated when a gas generating agent 6 burns and closing a space 12. The punched metal 11 reliably discharges a gas generated by combustion of the gas generating agent 6 through a gas discharge hole 8.

On inner surfaces of a large number of gas discharge holes 8 provided on the side cylinder 1a of the upper lid 2, a sealing member (e.g., an aluminum foil member) 10 is stuck and keeps inside of the housing 4 airtight with a packing 31 abutting on the ignitor holding portion 3a.

Next, an assembling process of the gas generator G1 shown in FIG. 1 will be described based on the drawing. First, the packing 31 is abutted on the ignitor holding portion 3a of the lower lid 3 and the ignitor 30 is fixed by caulking. Then, the ring member 9b is put in and the cooling/filtering member 7 is inserted. And then, the gas generating agent 6 is loaded inside the cooling/filtering member 7 and the fixing lid member 9a is disposed over the cushion member 5. The gas discharge hole 8 is covered with the upper lid 2 sealed by the sealing member 10 and the lower lid 3 and the upper lid 2 are joined. As a result, the gas generator

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G1 shown in FIG. 1 is integrated.

Next, an operation of a gas generator of the present invention will be described taking the gas generator shown in FIG. 1 for instance. When a collision detecting device mounted in a vehicle detects a collision of the vehicle, the ignitor 30 ignites in response to a detection signal and the gas generating agent 6 is ignited by a flame of ignition. Then, a high-pressure gas starts to be generated by combustion of the gas generating agent 6. When gas pressure in the housing 4 rises and reaches a predetermined pressure, the sealing member 10 bursts and a high-pressure gas spouts out of the gas discharge holes 8 and instantaneously inflates an airbag (not shown).

A slag generated at the time of combustion of the gas generating agent 6 is collected and cooled in a process of passing through the cooling/filtering member 7 and supplied for the airbag. A temperature and a pressure in the housing 4 become instantaneously high after combustion starts. Housing structural members (the side cylinder 1, the upper lid 2 and the lower lid 3) made of iron or steel can be thinner in thickness than one made of an aluminum alloy. It is possible to make component members (the side cylinder 1, the upper lid 2 and the lower lid 3) to be thin by using iron or steel compared with using an aluminum alloy. It becomes easy to apply even an organic compound gas generating

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agent which is hard to be used for a housing made of an aluminum alloy. The kind of types of applicable gas generating agents can be increased and the gas generator can be readily designed.

In a gas generator, wherein a length (L) of a housing is shorter than a diameter (D) thereof (a gas generator, wherein L/D is no more than 1), if the upper lid 2 and the lower lid 3 are thick, the gas generating agent cannot be loaded sufficiently. Therefore, increase of weight is required to be controlled. There is an upper limit to the thickness of the upper lid 2 and the lower lid 3 for a reason mentioned above. A design, wherein the upper lid 2 and the lower lid 3 are not damaged but allowed to be modified, is desired. Particularly, the lower lid 3 requires to have an ignitor holding portion. In a case where the ignitor holding portion is fixed by welding or caulking as another member, it is hard to prevent a damage of a fixing and joining portion accompanied with a modification thereof in a design in which the modification is allowed. However, the damage can be readily prevented because of integral forming. Even if L/D is no more than 1, a rigidity of the lower lid 3 improves and the modification of the gas generator can be prevented.

The present embodiment, wherein the bottom plate 3f of the lower lid 3 and the top plate 2a of the upper lid 2 are in a ball-like shape, is described. However, the bottom plate 3f and the top

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plate 2a may be flat.

As gas generating agents capable of being used in the present invention, gas generating agents, wherein nitrogen containing organic-compounds such as tetrazoles compounds, triazoles compounds, azodicarbonamides compounds, and guanidines compounds are used as fuel, and oxidizing agents such as nitrates, oxohalogenates are added thereto and mixed therewith, may be illustrated.

The gas generator according to the present invention is not limited to the embodiment mentioned above. For example, it is possible to form the ignitor holding portion 3a eccentrically on the bottom plate 3f and form 2 and more ignitor holding portions.

Capability of Exploitation in industry

According to the gas generator for an airbag of the present invention described above, by making a lower lid of iron or steel and forming an ignitor holding portion integrally in a center thereof, it is possible to omit a joining and fixing process and a sealing process conventionally required for joining and fixing other members. It is also possible to prevent a damage of a fixing and joining portion. As a result, an organic-compound gas generating agent, wherein an internal pressure is likely to be high at the time of burning thereof, can be readily applied.

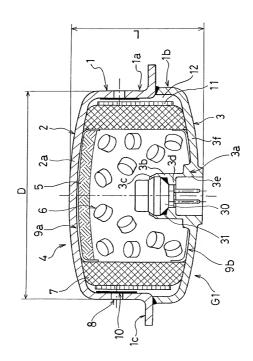
Claims

- 1. A gas generator comprising a housing (4) formed by joining an iron- or steel-made upper lid (2), containing a top plate (2a) and 5 a side cylinder (1a) extending downward from the entire circumferential edge thereof and provided with many gas discharge holes (8), with an iron- or steel-made lower lid (3) containing a bottom plate (3f), a side cylinder (1b) extending upward from the entire circumferential edge thereof, and an ignitor holding portion (3a) formed integrally with the bottom plate (3f) and for fixing by caulking an ignitor (30), the ignitor (30) and a gas generating agent (6) being arranged in the housing (4) in the order mentioned from the center thereof.
 - 2. The gas generator according to claim 1, wherein a flange (1c) extends vertically outward from the side cylinder (1a) of the upper lid (2).
 - The gas generator according to claim 1, wherein the integral forming is done by a repetition of partial pressuring the iron or steel to flow.
- 4. The gas generator according to claim 3, wherein the lower lid(3) is formed into a ball-like shape.
 - 5. The gas generator according to claim 3, wherein the ignitor holding portion (3a) stands on a wall thickness portion (3e) of the

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bottom plate (3f) of the ball-like lower lid (3) and comprises an inner cylindrical portion (3b) for holding the ignitor (30), a protruding portion (3d) protruding from the inner cylindrical portion (3b) into a center thereof and mounting the ignitor (30), and a bending portion (3c) extending from the inner cylindrical portion (3b), bending towards a center thereof, and fixing the ignitor (30) by caulking.

- 6. The gas generator according to claim 1, wherein a relation of an outside diameter (D) of the side cylinder (1) and a length (L) from the upper lid (2) to an outer surface of the lower lid (3) is $L/D \le 1$.
- 7. The gas generator according to claim 1, wherein the gas generating agent (6) is an organic-compound gas generating agent of which main component is a nitrogen containing organic compound.



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Declaration and Power of Attorney For Patent Application

特許出願宣言書及び委任状

Japanese Language Declaration 日本語宣言書

下記の氏名の発明者として、私は以下の通り宣言します。	As a below named inventor, I hereby declare that:
私の住所、私書箱、国籍は下記の私の氏名の後に記載された通 りです。	My residence, post office address and citizenship are as stated next to $\ensuremath{\mathrm{nv}}$ name.
下記の名称の発明に関して請求範囲に記載され、特許出願している発明内容について、私が最初かつ唯一の発明者(下記の氏名が一つの場合)もしくは最初かつ共同発明者(下記の名称が複数の場合)であると信じています。	I believe I am the original, first and sole inventor(if only on name is listed below) or an original, first and joint inventor(I: plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled. GAS GENERATOR
は、 は は は は は は は は は は は は は は は は は は は	the specification of which is attached hereto. x was filed on July 26, 2000 as United States Application Number or PCT International Application Number PCT/JP00/04980 and was amended on (if applicable).
私は、特許請求範囲を含む上記訂正後の明知書を検討し、内容 を理解していることをここに表明します。	I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.
&は、連邦規則法典第37編第1条56項に定義されるとおり、特 許資格の有無について重要な情報を開示する義務があることを 認めます。	I acknowledge the duty to disclose information which is material to patentability as defined in Title37, Code of Federal Regulations, Section 1.56.
Pag	e l of 4

Japanese Language Declaration

(日本語宣言書)

私は、米国法典第35編 1 1 9条(a)-(d)項又は3 6 5条(b)項に 基づき下記の、米国以外の国の少なくとも一カ国を指定してい る特許協力条約365(a)項に基づく国際出願、又は外国での特 許出願もしくは発明者証の出願についての外国優先権をここに 主張するとともに、優先権を主張している、本出願の前に出願 された特許または発明者証の外国出願を以下に、枠内をマーク することで、示しています。

Prior Foreign Application (s)

外国での	先行具	166

11-213351	Japan
(Number)	(Country)
(番号)	(国名)
(Number)	(Country)
(番号)	(国名)
(Number)	(Country)
(番号)	(国名)
(Number)	(Country)
(1) (番号)	(国名)
利は、第35編米国法典119 st	MeI項に基づいて下記の米国特許
出願規定に記載された権利を3	ことに主張いたします。

(Application No.) (Filing Date) hills (出願番号)

科は、下記の米国法典第35編 120条に基づれて下記の米国特許 出願に記載された権利、又は米国を指定している特許協力条約 365 条(c)に基づく権利をここに主張します。また、本出願の各 請求範囲の内容が米国法典第35編112条第1項又は特許協力条 約で規定された方法で先行が米国特許出願に開示されていない限 り、その先行米国出願書提出日以降で本出願書の日本国内また は特許協力条約国際提出日までの期間中に入手された、連邦規 則法典第37編 1 条56項で定義された特許資格の有無に関払軍要 な情報について開示義務があることを認識しています。

(Application No.) (出願番号)	July 26, 2000 (Filing Date) (出願日)
(Application No.)	(Filing Date)
(出願番号)	(出願日)

私は、私自身の知識に基づいて本宣言書中で私が行なう表明 が真実であり、かつ私の入手した情報と私が信じるところに基 づく表明が全て真実であると信じていること、さらに故意にな された虚偽の表明及びれと同等の行為は米国法典第18編第1001 条に基づき、罰金または拘禁、もしくはその両方にめ処罰され ること、そしてそのような故意による虚偽の声明を行なえば、 出願した、又は既に許可された特許の有効性が失われることを 認識し、よってここに上記のごとく宣誓を致します。

I hereby claim foreign priority under Title 35, United States code, Section119(a)-(d) or 365(b) of any foreign application(s) for patent or inventor's certificate, or Section365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate, or PCT International application having a filing date before that of the application on which priority is claimed.

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Yes	No
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Yes	No
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Yes	No
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	Yes tity Yes tity Yes tity Yes tity Yes tity Yes

I hereby claim the benefit under Title 35, United States Code, Section 119 (e) of any United States provisional application(s) listed below.

(Application No.) (出願番号) (Filing Date) (出願日)

I hereby claim the benefit under Title35, United States Code, Section 120 of any United States application(s), or Section365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of Title35, United States Code Section112, I acknowledge the the duty to disclose information which is material to patentability as defined in Title37. Code of Federal Regulations, Section1.56 which became available between the filing date of the prior application and the national or PCT International filing date of application. Pending

(Status: Patented, Pending, Abandoned) (現況:特許許可済、係属中、放棄済)

(Status: Patented, Pending, Abandoned) (現況:特許可済、係属中、放棄済)

l hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Japanese Language Declaration

(日本語宣言書)

委任状: 私は下記の発明者として、本出願に関す一切の手続き を米特許簡潔局に対して遂行する弁理士または代理人として、 下記の者を指名いたします。 (弁護士、または代理人の指名及び登録番号を明記のこと) POWER OF ATTORNEY: As a named inventor, ! hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith: (list name and registration number)



書類達付先 計 門 門		Send Correspondence to:	022850	
は安電話連絡先: (名前及び電話番号)		Direct Telephone Calls to:	(name and telephone n	umber)
唯一または第一発明者名		Full name of sole or first Akihiko SUEHIF		
発明者の署名 日	付	Inventor's signature		Date
ufi-		Akihika Sue	hiro	DEC. 2 O. 2001
PP.		Residence c/o Himeji Factory of NIPPO 3903-39, Toyotomi, Toyotomi Hyogo 679-2123 Japan		ISHA
国籍		Citizenship	JAPAN	
郵便の宛先		Post Office Address	same as abo	ve
第二共同発明者		Full name of second joint in	nventor, if any	<u> </u>
第二共同発明者の署名 日	付	Second Inventor's signature		Date
	_	Koji Janaka	,	DEC. 2 Q. 2001
住所		Residence c/o Himeji Factory of NIPPO 3903-39, Toyotomi, Toyotomi Hyogo 679-2123 Japah	N KAYAKU KABUSHIKI-KA	I SHA
国籍		Citizenship	JAPAN	
郵便の宛先		Post Office Address	same as abo	ve
(第三以降の共同発明者についても、同様に 署名すること)	記載し、	(Supply similar information and joint inventors.) Page 3 of 4	d signature for third	and subsequent

	ua	panese Language Declaration 3 -00	
第三共同発明者		Full name of third joint inventor, if any Takashi SASO	
第三共同発明者の署名	日付	Third Inventor's signature	Date
		Takashi Sasa	DEC. 2 O. 2001
住所		Residence	*
		c/o Himeji Factory of NIPPON KAYAKU KAB 3903-39, Toyotomi, Toyotomi-cho, Himeji Nyoso 679-2123 Japan	USHIKI-KAISHA -shi,
国籍		Citizenship JAPA	N
郵便の宛先		Post Office Address same	as above
第四共同発明者		Full name of fourth joint inventor, if an	у
第四共同発明者の署名	日付	Fourth Inventor's signature	Date
住所			
la de la companya de		Residence	
国籍		Citizenship	
郵便の宛先		Post Office Address	
第五共同発明者		Full name of fifth joint inventor, if any	
第五共同発明者の署名	日付	Fifth Inventor's signature	Date
住所		Residence	
		inortaine.	
国籍		Citizenship	
郵便の宛先		Post Office Address	
第六共同発明者		Full name of sixth joint inventor, if any	
第六共同発明者の署名	日付	Sixth Inventor's signature	Date
		Residence	
主所			
主所		Citizenship	

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